

Ship 25/11

Dart Aerospace Ltd.

48

Date: Monday, 10/22/2007 10:34:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP INSTALLATION RH (FOLDING)
Job Number : 35256	
Estimate Number : 11451	
P.O. Number :	Part Number : D412630014
This Issue : 10/22/2007 S.O. No. :	Drawing Number : D2801 UNDER REVIEW INSTALL
Prsht Rev. : NC	Project Number : N/A D2807 GAS SPRING
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1 PER MARK-VPS
Previous Run : 28151	Material : 07.10.22 DC
Written By : <u>[Signature]</u>	Due Date : 11/26/2007 Qty: 2 Um: Each
Checked & Approved By : <u>[Signature] 07.10.22</u>	
Comment : Est Rev:E 04.05.17 Reformat; Removed AN3-16A KJ/RF	
Est Rev:F 06-11-09 As per IIN D412-630 Rev K JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-630-014 CHG005

CHG006

07.10.30

07.10.22

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion	B34694
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Check Material for any Dents or Defects

07.11.06

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

2-Deburr and bevel ends for welding

07.11.06

07.11.06

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07.11.06

07.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap B34485PH 07.11.15 2

6.0

D28021

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D28021

Arm B35597
B35309PH 07.11.15 2

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end caps as per Dwg D2801 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

M105088M105844

2-Grind end cap welds flush as per Dwg D2801

PH 07.11.15 2SAD 07-11-15 (2)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PH 07-11-15 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 07-11-16 (2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 07-11-17 (2)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

2-Weld as per Dwg d2801

PH 07.11.19 2PH 07.11.19 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-11-19	11.0	3. Grind welds flush as per diag. 32801 endcap	SA	07-11-19	2			
		permanent change	A.A.	07-11-21	2			
07-11-21		Press bushing 2808 into arm # <u>B 35330</u>	mf CP	07-11-21	1		Calz, 1	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description:

a/r

AL ROD

Batch: M105058

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

Batch: M106030

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

19.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2012-107

Clevis D033585

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2022101

Spacer



SP Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2022-101 Spacer

1733985

SP

21.0

D2652

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2652

Bushing

1734893

SP

P18

22.0

D2803042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2803-042

Bracket Assembly

1033589

mf 07-11-28

23.0

D2804042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2804-042

Bracket Assembly

34018

SP

24.0

D2807

Gas Spring (Support Prop)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2807-041

Gas Spring

B35962 x 4mx

SP

25.0

D28101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2810-1

Strut

B353101P

25712

7/11/12 SP







B25712

1P

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-630-014 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR: <u>35256</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/28	# 2/ 38	4 Bushing D2652 was scrap. R.C. Employee was mistake the assembly wrong and ground parts to it		Remind employees to ^{and follow} look at the installation instructions during assembly's. Destroy / scrap.	TNF 07-11- 28	 07/11/28	 07/11/28	 07/11/28
					07-11- 28 mf			

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Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2813

Washer

1732726, SP

27.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN3-20A

Bolt

X SP M15438

28.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

QPick:

Qty Part Number

Description Batch

1 AN4-10A

Bolt

Q2 M104603, SP

29.0

AN816

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN8-16

Bolt

M105545, SP

30.0

AN3108

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN310-8

Nut

M105125, SP

31.0

MS24665285

Cotter Pins



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

M9003, 7/1/12 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: STEP INSTALLATION RH (FOLDING)

Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 MS24665-285 Cotter Pin

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 AN960JD10

Washer

M105792, SP

33.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M105906, SP

34.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 AN960JD816

Washer

M6956, SP

35.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3)

M100373, SP

36.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS21042L4

Nut (or -4)

M105054, 7/4/22 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP INSTALLATION RH (FOLDING)

Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS24693S280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS24693-S280

Screw

M105025

7/11/22 SLP (20)

38.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D412-630

mf 07-11-28 (2)

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/14/28 (20)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

41.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2022-101

Spacers

B33985

W

42.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2806-1

Bushing

B33590

W

43.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2806-3

Bushing

B29847

W 7/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP INSTALLATION RH (FOLDING)

Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

D356310

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

EYEBOLT

Batch: B29371

45.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

46.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-15A Bolt M104946

47.0

AN515A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-15A Bolt M105940

48.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M105906

49.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 35256

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4

Nut (or -4) M105054

CU

51.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5) M105430

PC 7/11/28 (2)

52.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 7/11/29 (42)

53.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-014

Location:

PPP Rev: C

AS 04/11/29 SD (x2)

54.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.29

Job Completion



11/07/11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

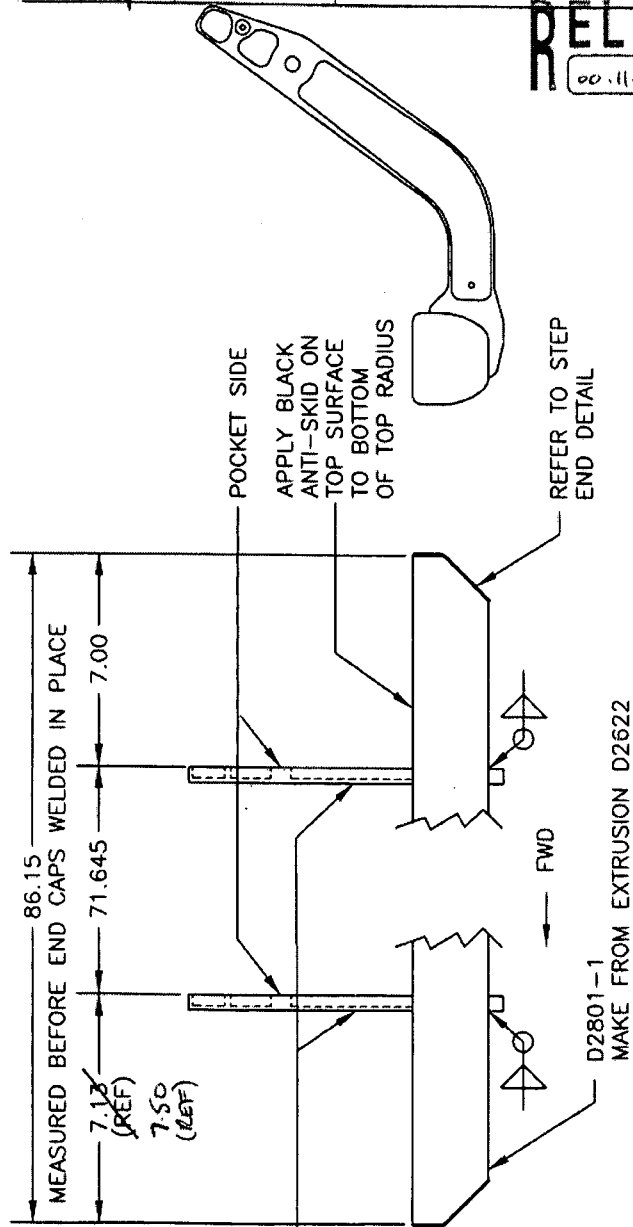
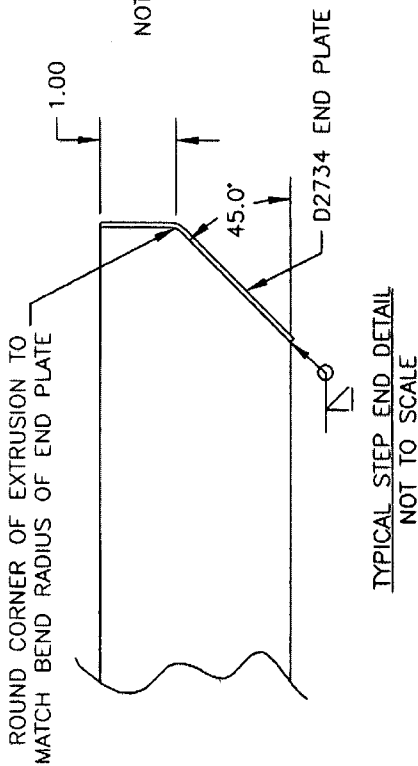
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2801	REV. A SHEET 1 OF 1
DATE 00.11.03		TITLE STEP WELDMENT	SCALE NTS
A	00.11.03	NEW ISSUE	
A1	03.08.15	7.50 WAS 7.13	

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2802-041 ARM
(2 PLACES)
USE D2802-042
FOR D2801-042
RH STEP ASS'Y

SHOP CO
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35250

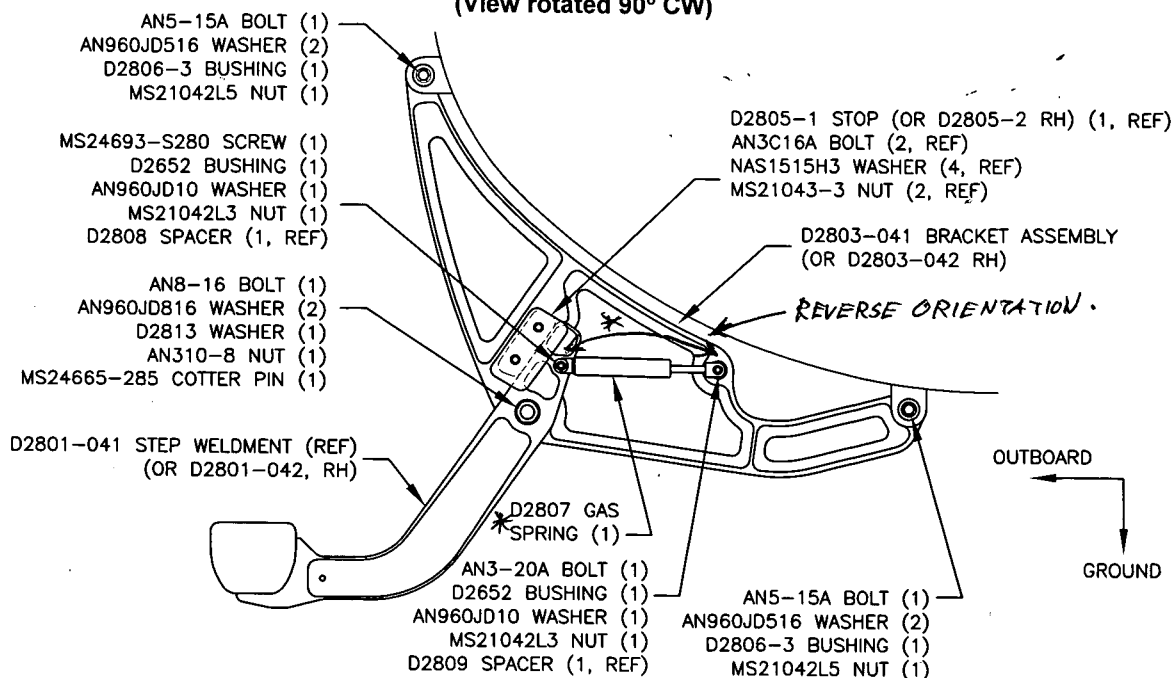
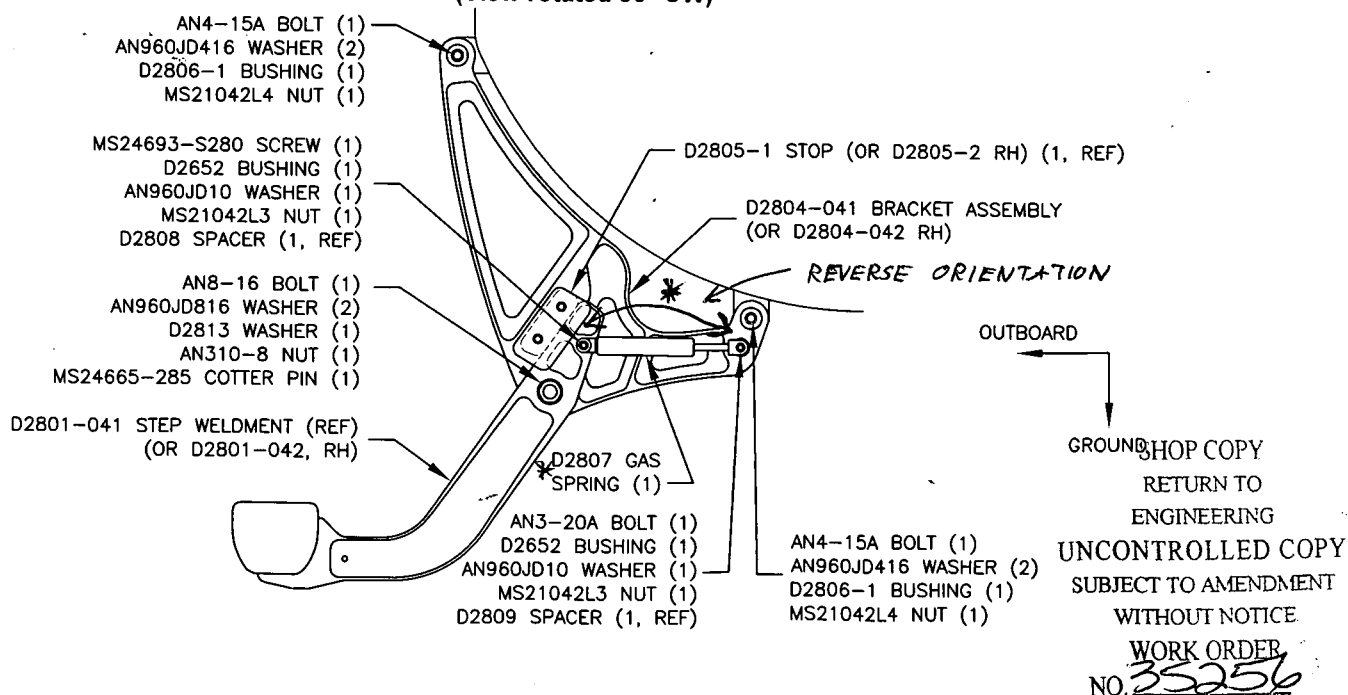
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

MAKE FROM EXTRUSION D2622

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D412-630-013/-014 Heli-Access-Step™ Installation**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation**
(View rotated 90° CW)

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Revision: K
Date: 06.10.05